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D4764-5**Job Sheet 202028****Part No:** D4764-5**Job Qty:** 80 pcs**Part Name:** Bushing**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/18/19**Job Tracking No:****Due Date:** 11/18/19**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV B SHEET 2 IPP REV:A NEW ISSUE 13-03-27 JLM VERIFIED BY:DD IPP REV:B 13.11.14 AS PER
DWG REV.B DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	80 pcs	11/18/19	11/18/19	0.50	6.07	Hardinge - 1		OK/BM 19-11-19
120	QC 8	80 pcs	11/18/19	11/18/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Packaging 3-1 - Stock - B4B	80 pcs	11/18/19	11/18/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		

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Container No: S233271**Part:** D4764-5**Job No:** 202028**Serial No/Batch:** S233271**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/20/19

DAS

52/19/11/20

9-89

Oscar

NOV 21 2019

Packaging 3 - 3 - B4B ✓

ST 114

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

140 QC 21 - SA

80 pcs ✓

11/18/19

0.00 0.00

QC 21 - SA - 21 ✓

ST 114

QC 21 - SA - 70

QC 21 - SA - 53

DAS
21
9-08

NOV 21 2019

Part Op 100 - Hardinge - 1-TURN AS PER FOLIO FB180 & DWG ,
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item
M303R1.000

Component Name
303 Round Bar 1.00

Quantity
5 ft (.0625 ea)

Operation
100-Hardinge - 1

Container

5229477

Job Allocations

Operation

100-Hardinge - 1

Component Part

M303R1.000

Required

5

Inventory

26

Allocated

0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.621Inches + 0.008 - 0.001	0.629 0.620	0.620 Diameter	MIC
2	Bushing	0.075Inches ± 0.010	0.085 0.065	0.080	vern
3	Bushing	0.210Inches ± 0.010	0.220 0.200	0.215	vern
4	Bushing	0.750Inches ± 0.010	0.760 0.740	0.750	vern
5	Bushing	0.060Inches ± 0.010	0.070 0.050	0.062	vern
6	Bushing	0.010Inches ± 0.010	0.020 0.000	0.011 Radius	Gauge
7	Bushing	0.990Inches + 0.004 - 0.001	0.994 0.989	0.989 Diameter	MIC
8	Bushing	0.386Inches + 0.006 - 0.001	0.392 0.385	0.386 Diameter	vern

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Entered: _____ Date: _____ WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DEPARTMENT/PROCESS

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Skid-tube ☐
Machining ☐
Large Fab ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Job: _____
Part No. _____

MRB (QS1042)

QTY Affected :

Sequence #:

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge
☐	☐	☐
Bending	Misaligned/off center	Folio/Program
☐	☐	☐
Crushing	BOM/Route	Grain Direction
☐	☐	☐
Cracks	Broken/Damage/Defect	Weld
☐	☐	☐
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled
☐	☐	☐
Marks/Chatter	Drill Holes	Out of Sequence
☐	☐	☐
Mislabeled	Fit/Function	Off-set/Set-up
☐	☐	☐

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

Other/Details:

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐